

Date: Thursday, 5/4/2006 11:09:58 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR WINDOW
Job Number : 26931	
Estimate Number : 10457	
P.O. Number : N/A	Part Number : D32121
This Issue : 5/4/2006 S.O. No. : N/A	Drawing Number : D3212 REV <i>KB</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : <i>KB</i>
Previous Run : 25253	Material : Multiples of 4
Written By : _____	Due Date : 5/18/2006 Qty: <i>5</i> Um: <i>✓</i> Each
Checked & Approved By : _____	
Comment : Est Rev: A New Issue 05-11-09 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXANS125	1/8" Lexan Sheet
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Comment: Qty.: 1.0232 sf(s)/Unit Total : 10.2323 sf(s)

Material: 0.125" Polycarbonate *Polycast II*

~~(MLEXANS125)~~ *(M-ACRYLIC-S.125)*

Identify as D3212-1

Batch: *M17626 M100724*

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blanks: 15.250" x 9.200" (+0.000/-0.010)

3.0	HAAS1 <i>Water Jet</i>	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine D3212-1 as per Folio FA349 and Dwg D3212 Stack of 4

Dwg Rev: *B*

Prog. Rev: *B*

(5)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M100724

(5)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Feb 10 13 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 07/07/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/4/2006 11:09:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR WINDOW

Job Number: 26931

Part Number: D32121

Job Number:



Seq. #:

Machine Or Operation:

Description :

D27281

Dart Logo label small



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Qty Part # Description Batch

1 D2728-1 Dart Logo label

B24215

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Debur

2-Polish windows using Novis 1,2,3, plastic Polish,

3-Install label as per Dwg D3212

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1-Wrap in plastic wrap after inspection

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S-89

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

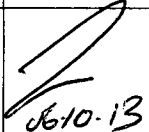
Inspection Level 21

Job Completion



U 07.02.21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/10/13	7.2	Please add Polish window as shown. Permanent change					 06/10/13

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26931
Description: Floor Window		Part Number:	D3212-1
Inspection Dwg: D3212	Rev: AB	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.734	+/-0.005	12.729	✓		vern	
6.367	+/-0.005	6.366	✓		vern	
0.625	+/-0.005	0.625	✓		vern	
Ø 0.156	+0.005/-0.000	0.156	✓		vern	
R0.25	+/-0.030	R0.25	✓		Radius Gauge	
8.150	+/-0.005	8.150	✓		vern	
3.750	+/-0.005	3.747	✓		vern	
0.313	+/-0.010	0.315	✓		vern	
15.14	+/-0.030	15.12	✓		measuring tape	
12.520	+/-0.005	12.516	✓		vern	
6.260	+/-0.005	6.260	✓		vern	
1.312	+/-0.005	1.310	✓		vern	
0.313	+/-0.010	0.316	✓		vern	
3.750	+/-0.005	3.753	✓		vern	
8.150	+/-0.005	8.152	✓		vern	
8.462	+/-0.005	8.463	✓		vern	
9.09	+/-0.030	9.09	✓		vern	

Measured by: <i>m.m</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 06.10.12	Date: 06.10.13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

DART

DESIGN		DRAWN BY		DART AEROSPACE LTD	
CP		SSH		HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. B	
<i>[Signature]</i>	<i>[Signature]</i>	D3212		SHEET 1 OF 1	
DATE		TITLE		SCALE	
06.04.13		FLOOR WINDOW		1:3	
A	03.09.03	NEW ISSUE			
B	06.04.13	UPDATE MATERIAL PER NCR 029			

